

FIG.1

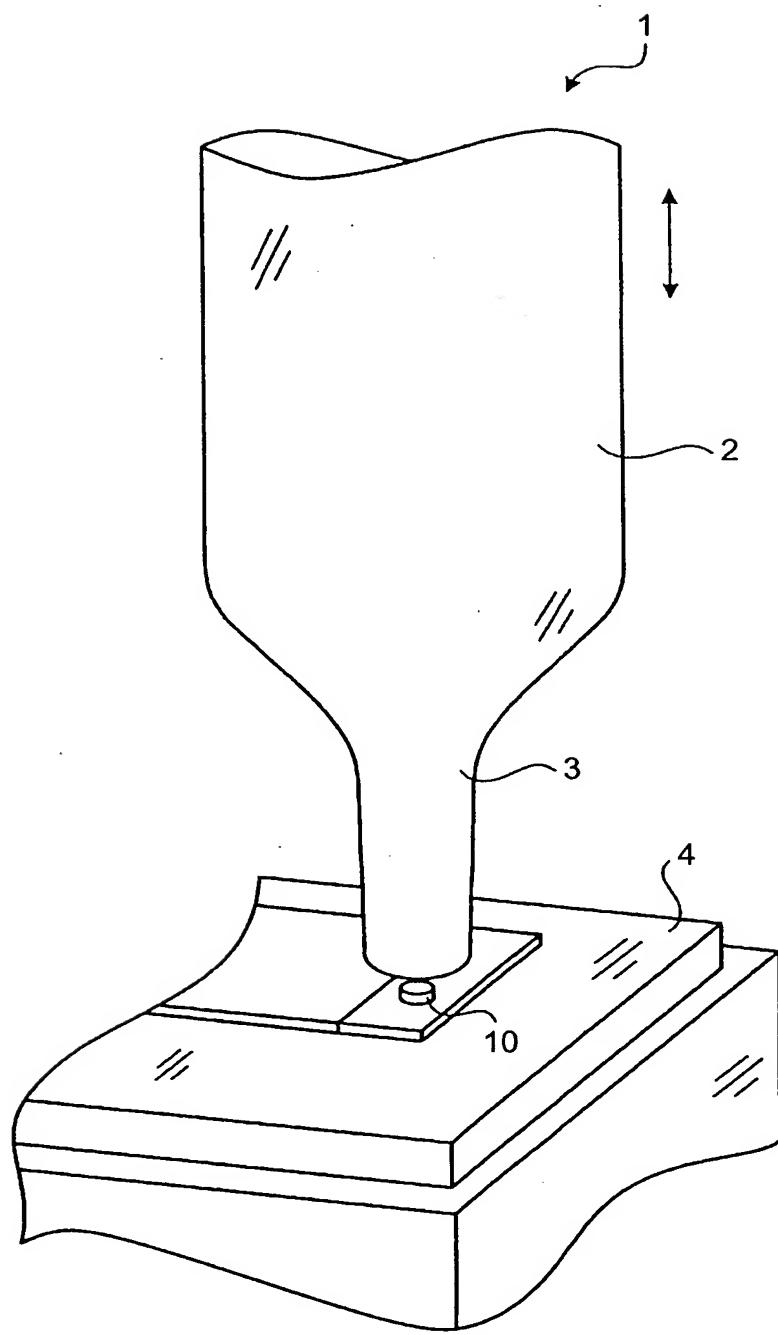


FIG.2

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EFFECTS MEASURES	REDUCTION OF ENERGY APPLIED	REDUCTION OF DEFORMATION OF MOLten RESIN	IMPROVEMENT IN DEFORMATION DIRECTION OF MOLTEN RESIN	RELAXATION AND HOMOGENIZATION OF INTERNAL STRESS	REDUCTION OF SENSITIVITY TO POSITIONING ERROR
ENLARGE DIAMETER OF BOTTOM OF RESIN	<input type="circle"/>			<input type="circle"/>	
PROVIDE CONCAVE PORTION IN CENTER OF RESIN		<input type="circle"/>		<input type="circle"/>	
INCLINE HORN			<input type="circle"/>	<input type="circle"/>	
PROVIDE R-SHAPED INLET OF HOLE OF RESIN				<input type="circle"/>	
PERFORM HEATING OF HORN				<input type="circle"/>	
PROVIDE HIGH FREQUENCY ULTRASONIC WAVE				<input type="circle"/>	

FIG.3

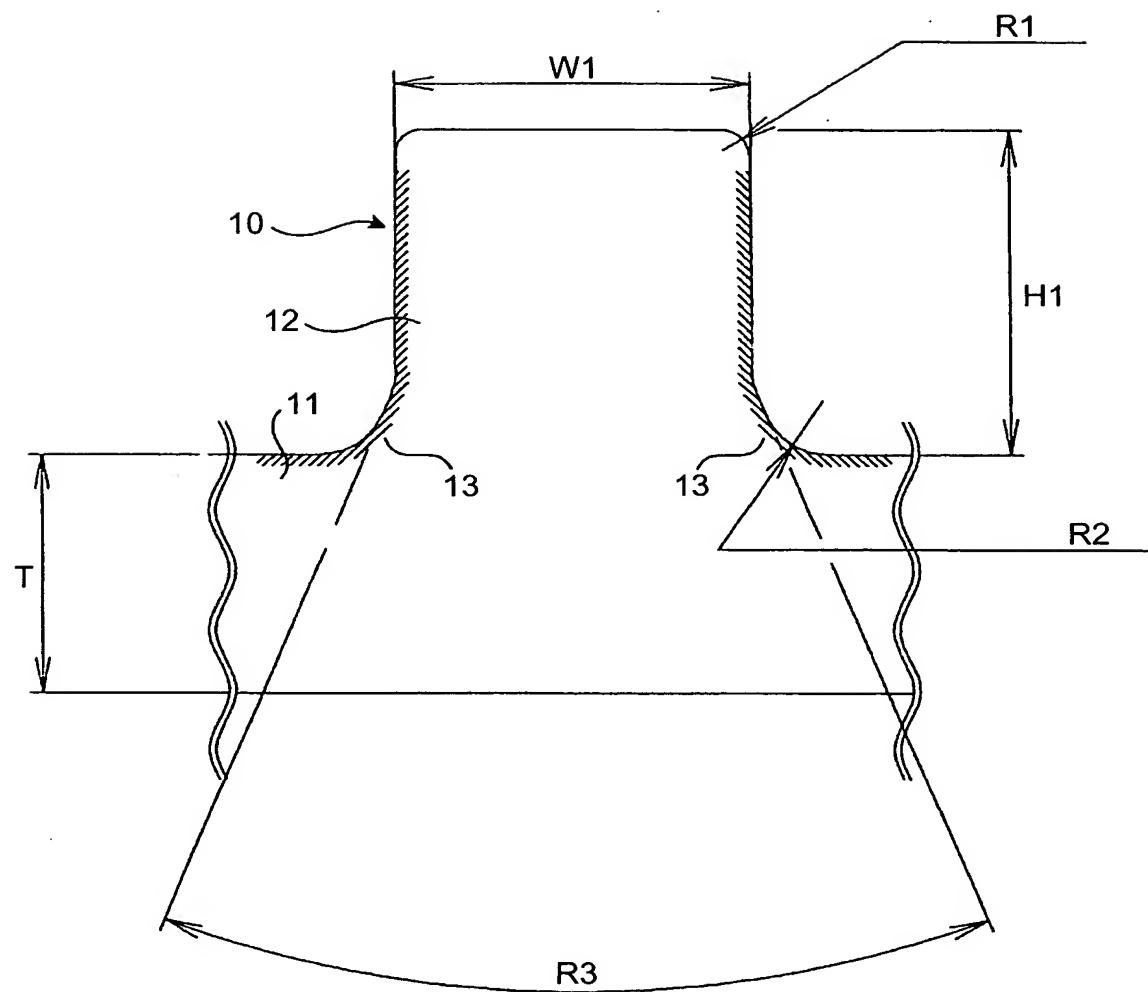


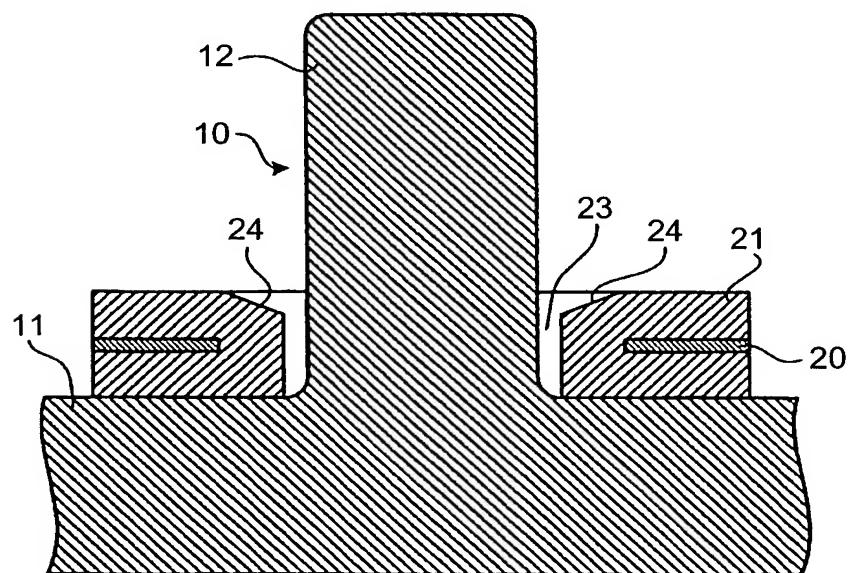
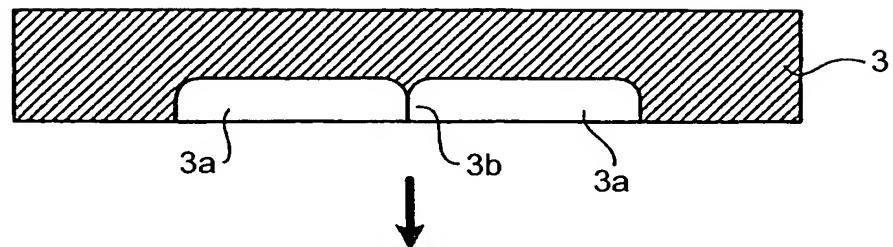
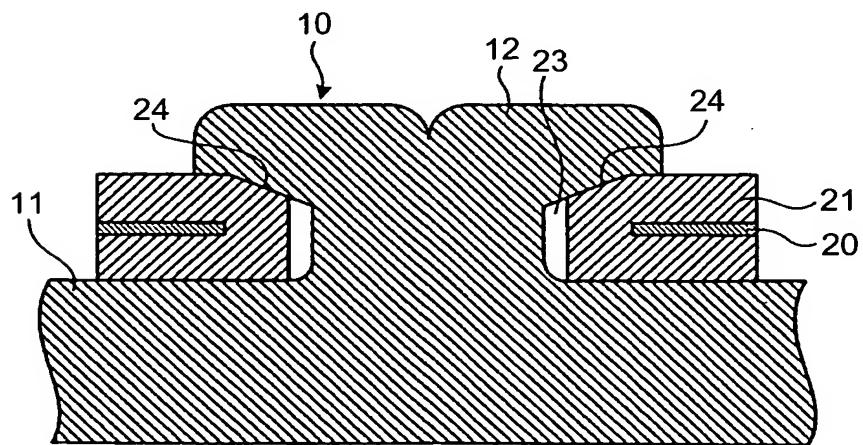
FIG.4**FIG.5**

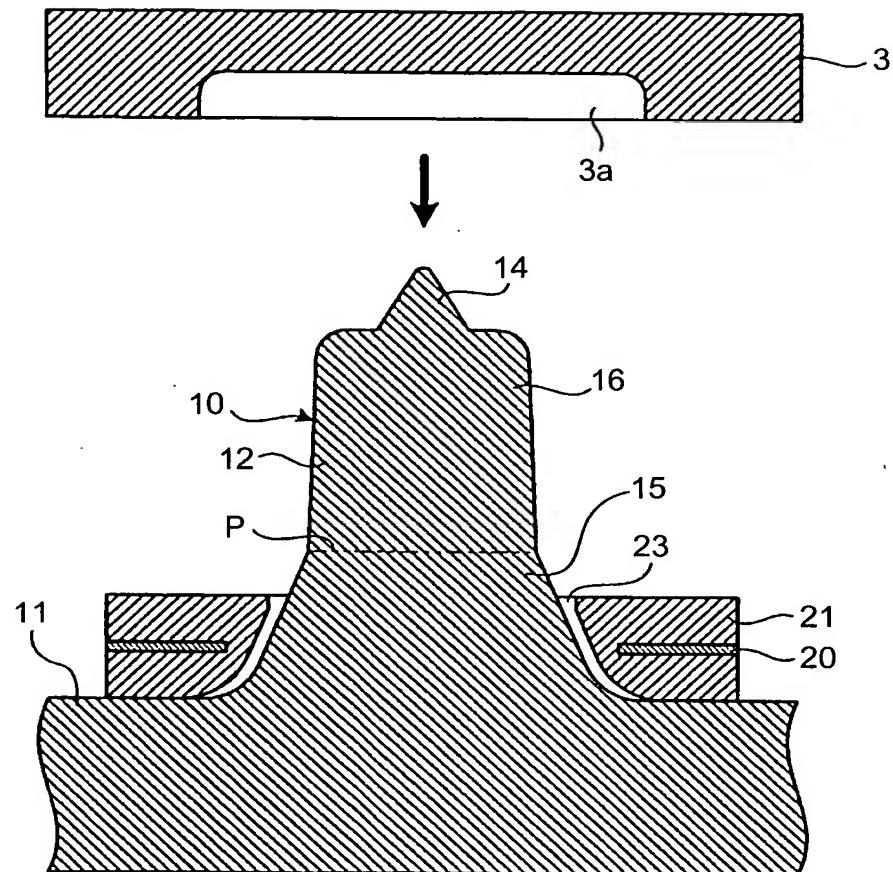
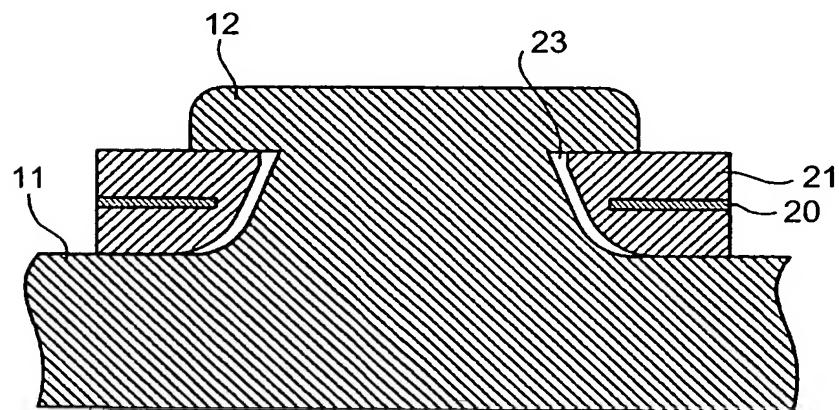
FIG.6**FIG.7**

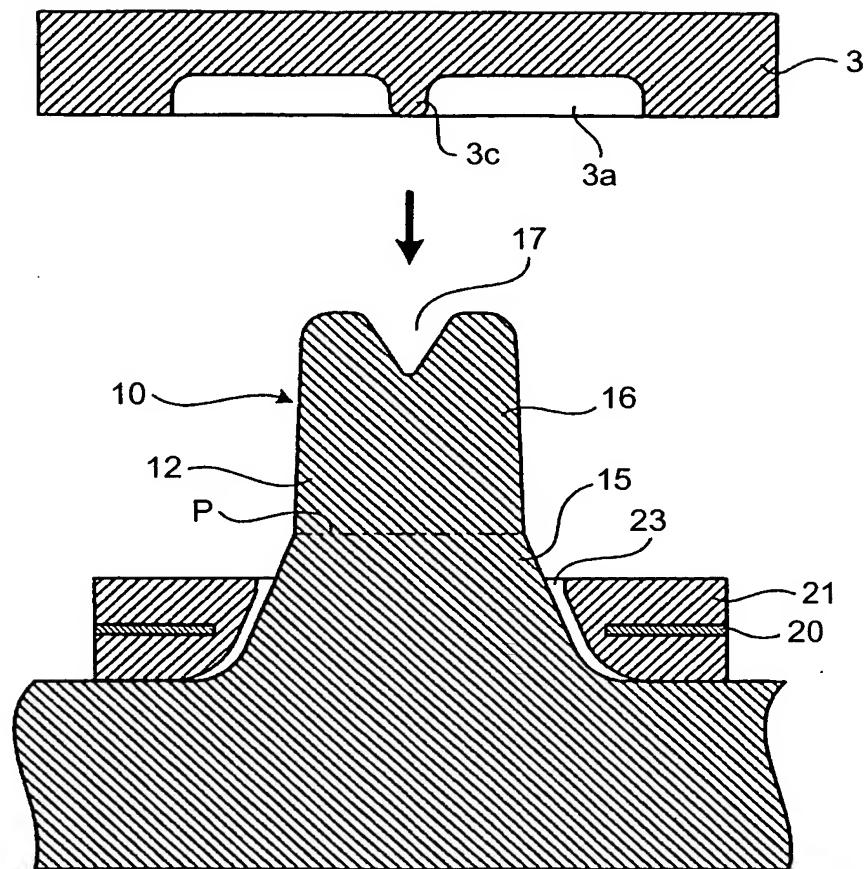
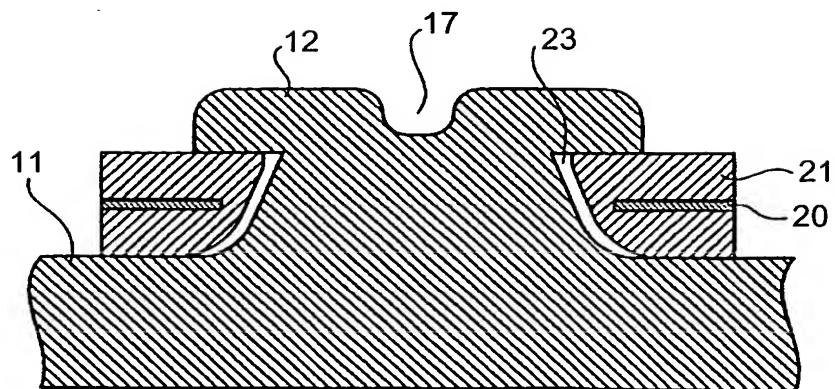
FIG.8**FIG.9**

FIG.10

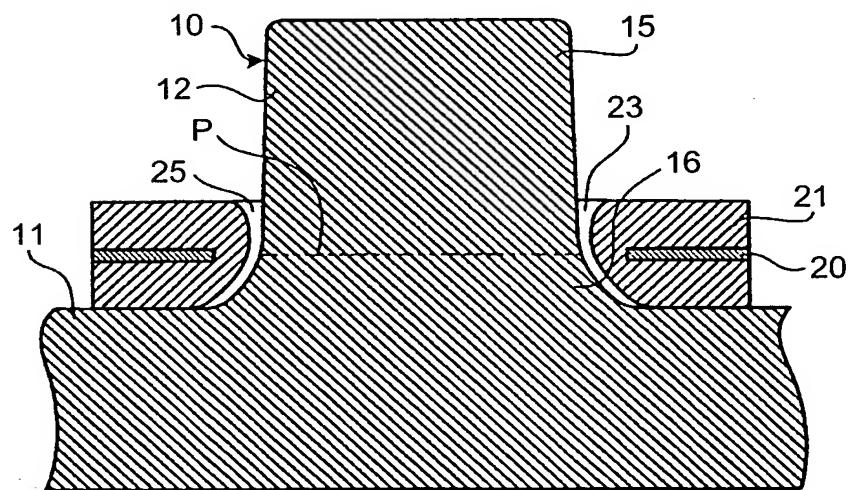
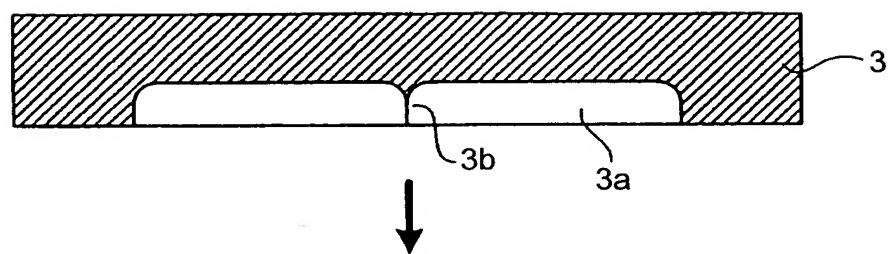


FIG.11

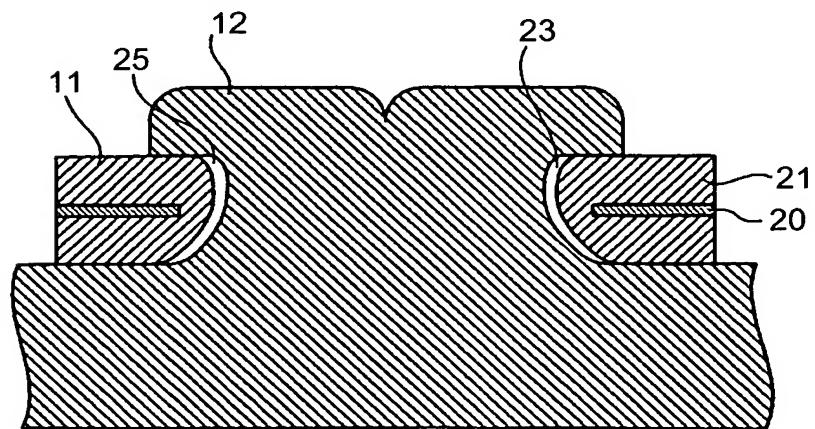


FIG.12

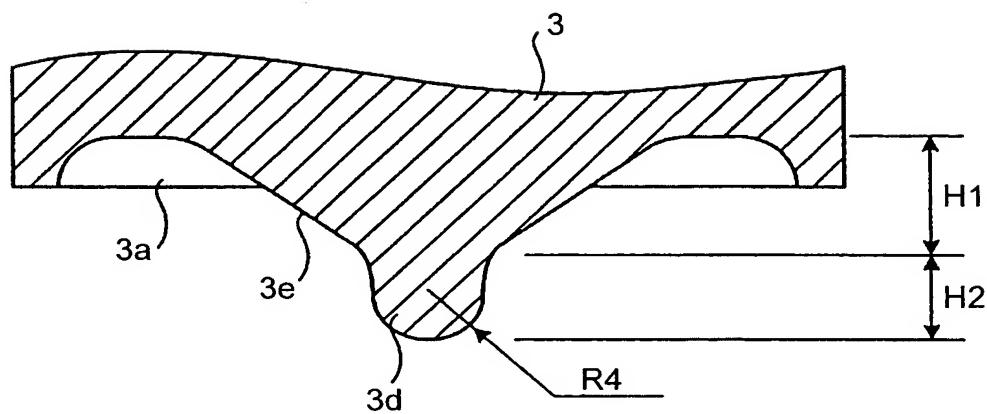


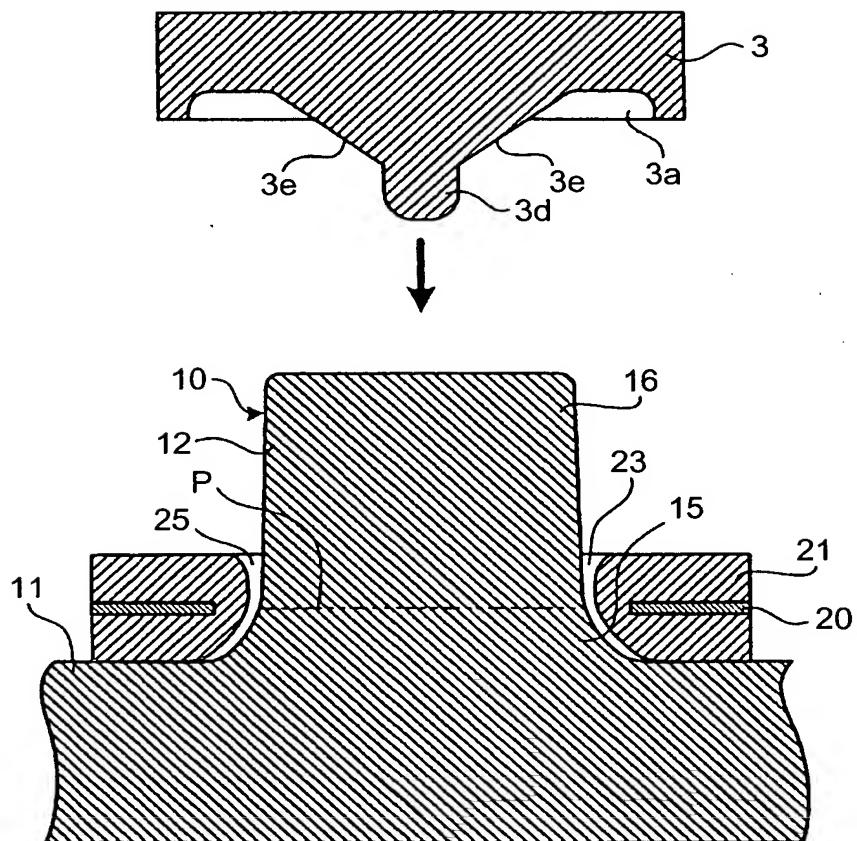
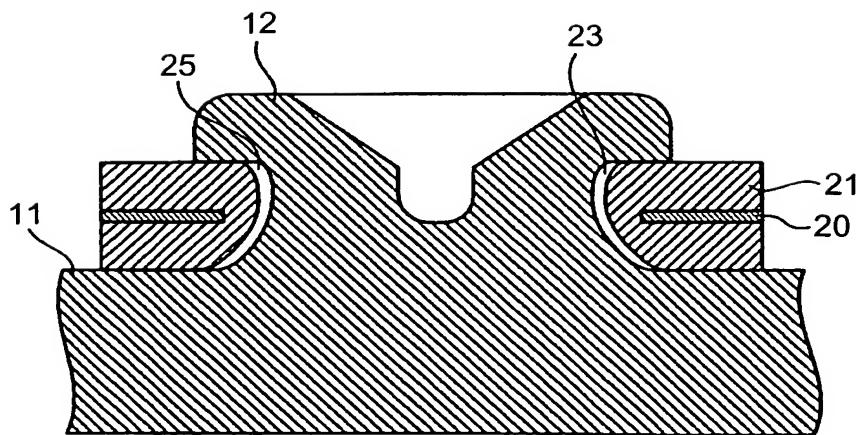
FIG.13**FIG.14**

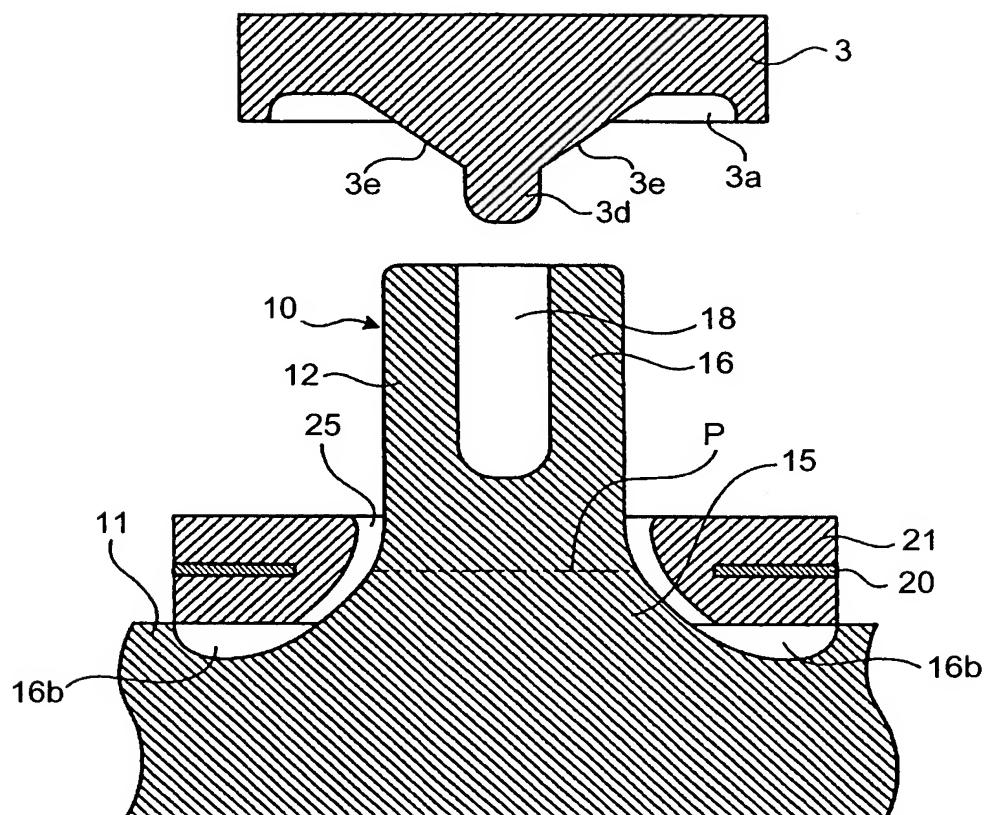
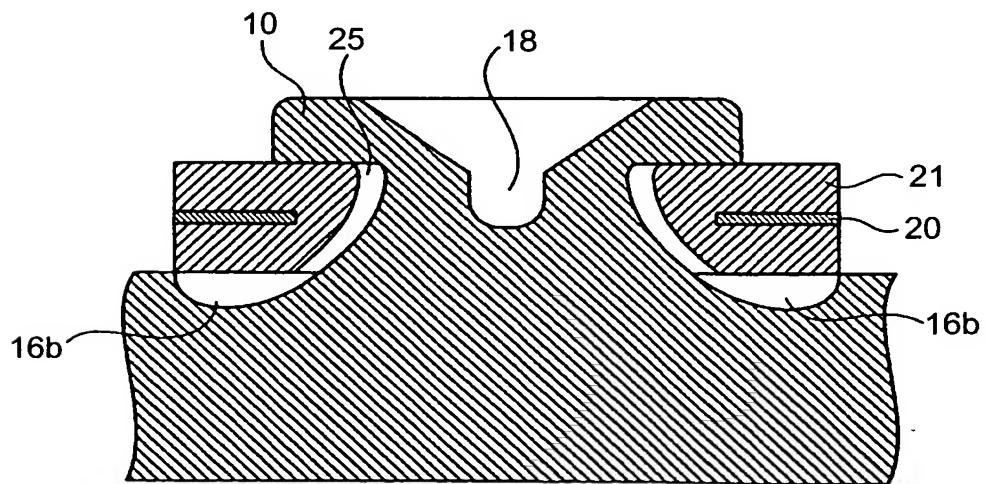
FIG.15**FIG.16**

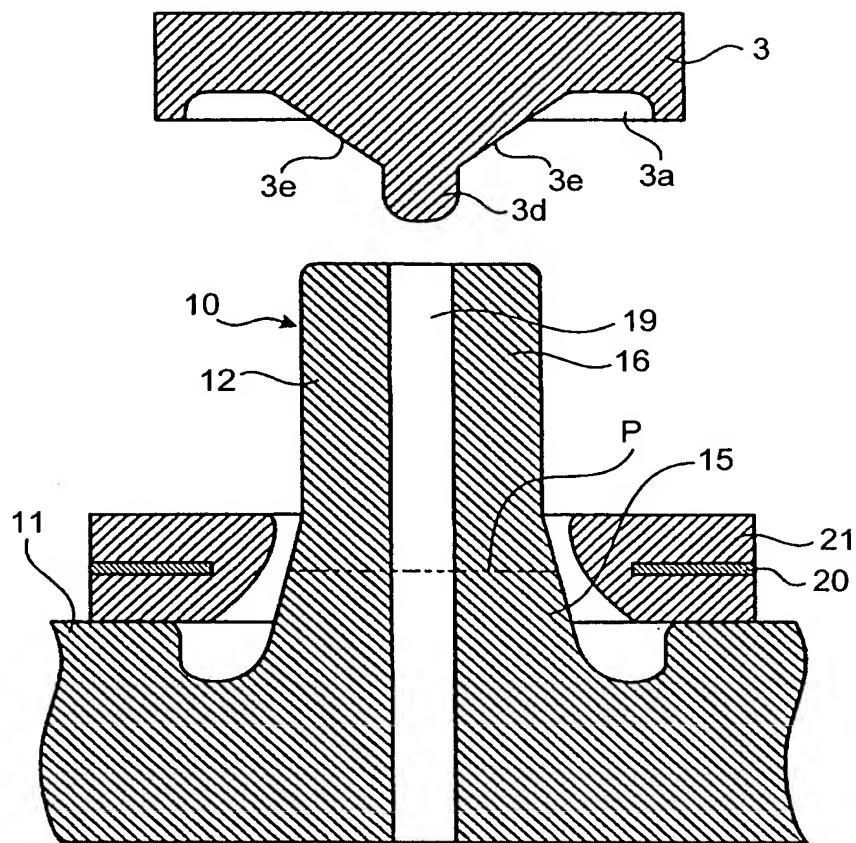
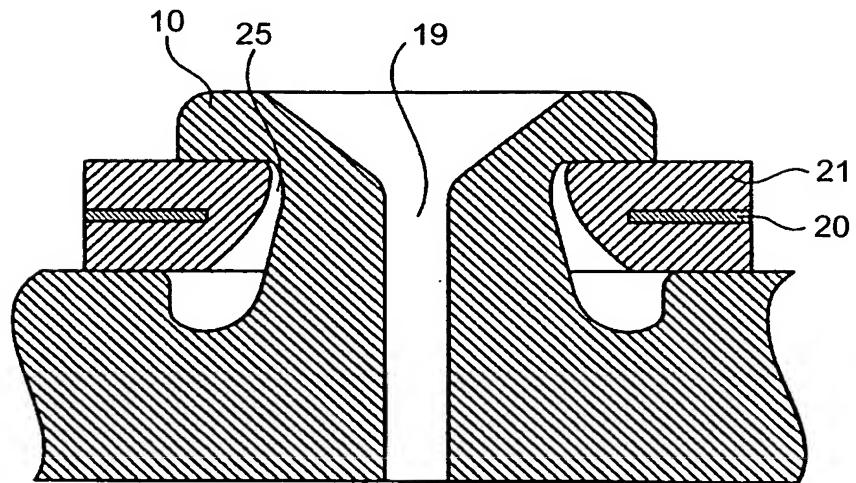
FIG.17**FIG.18**

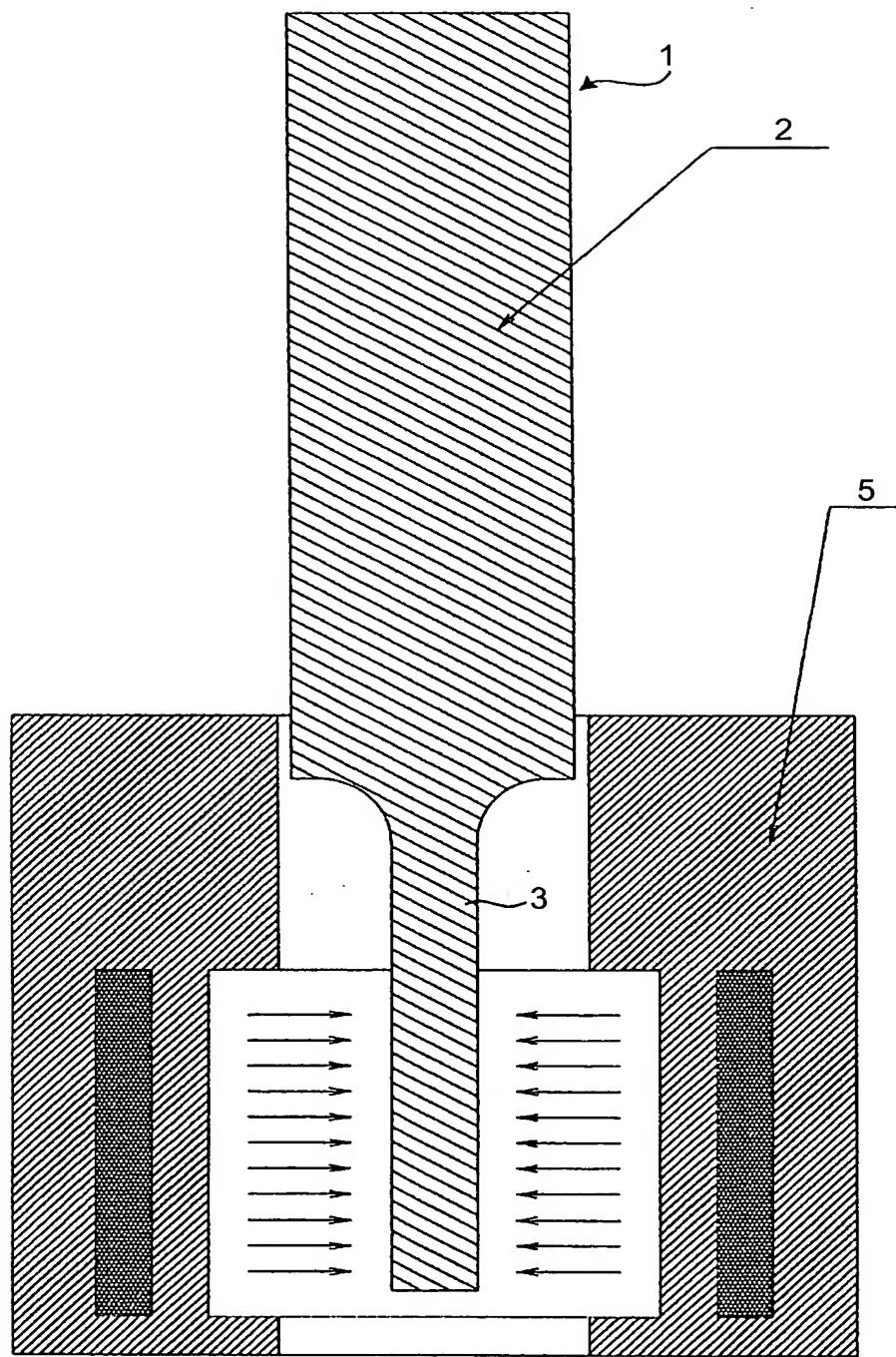
FIG.19

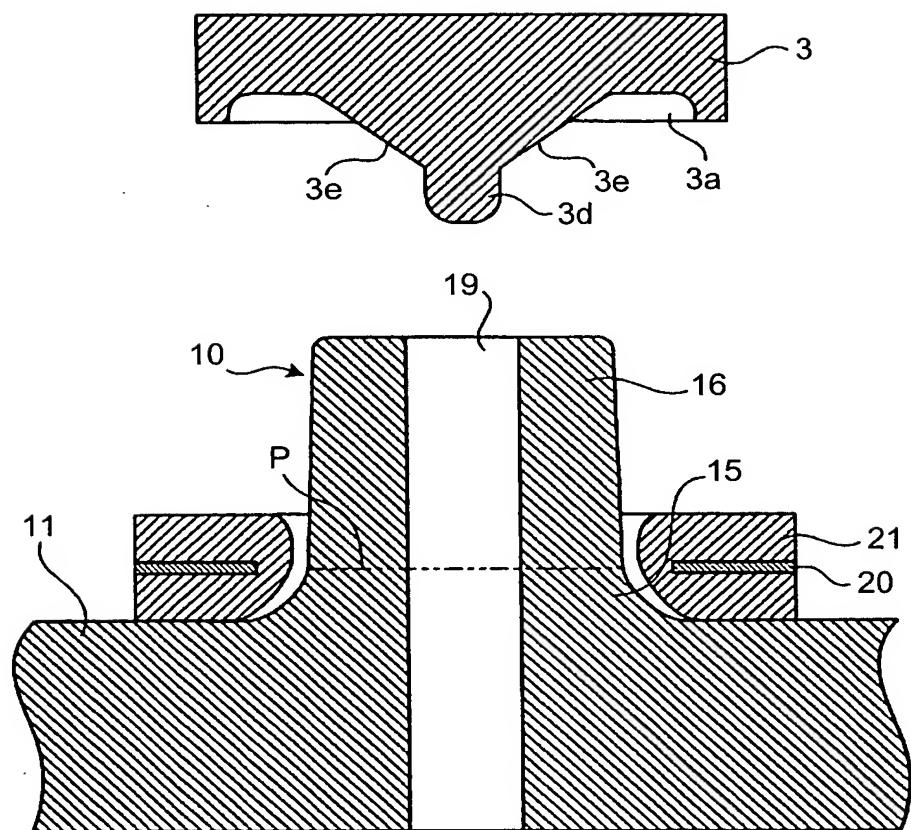
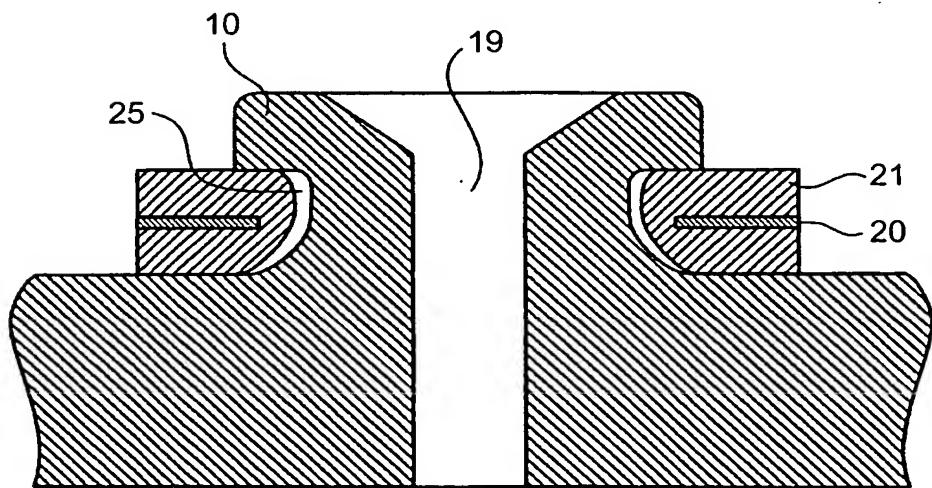
FIG.20**FIG.21**

FIG.22

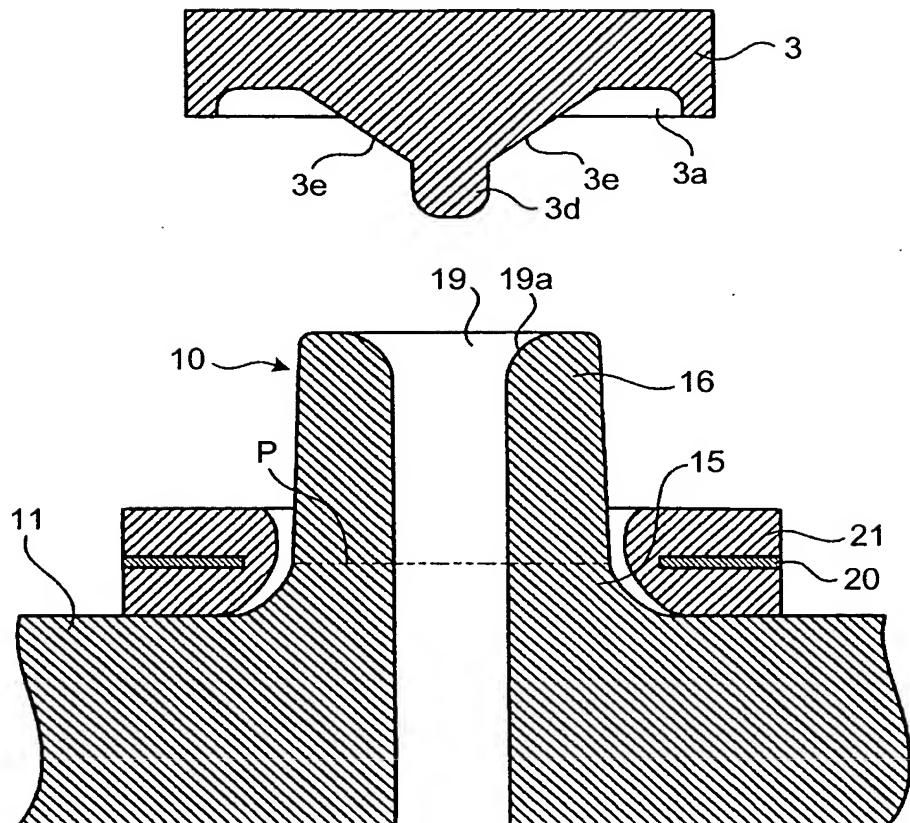


FIG.23

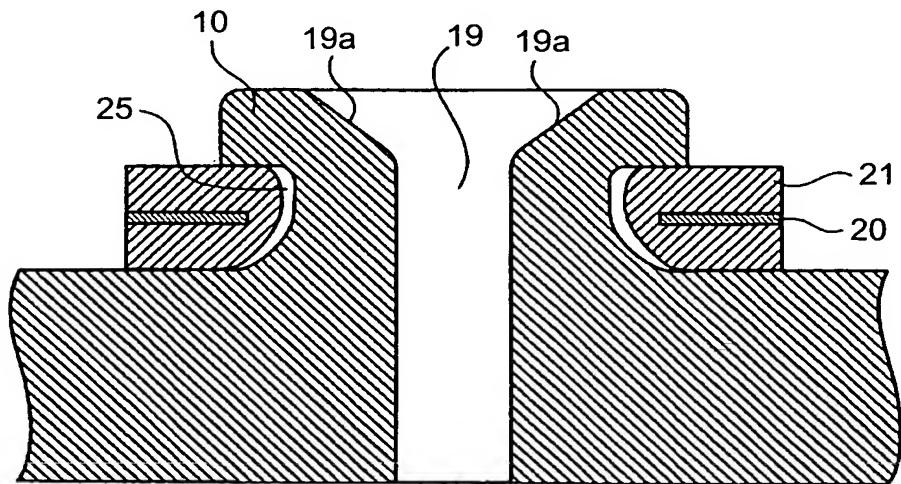


FIG.24

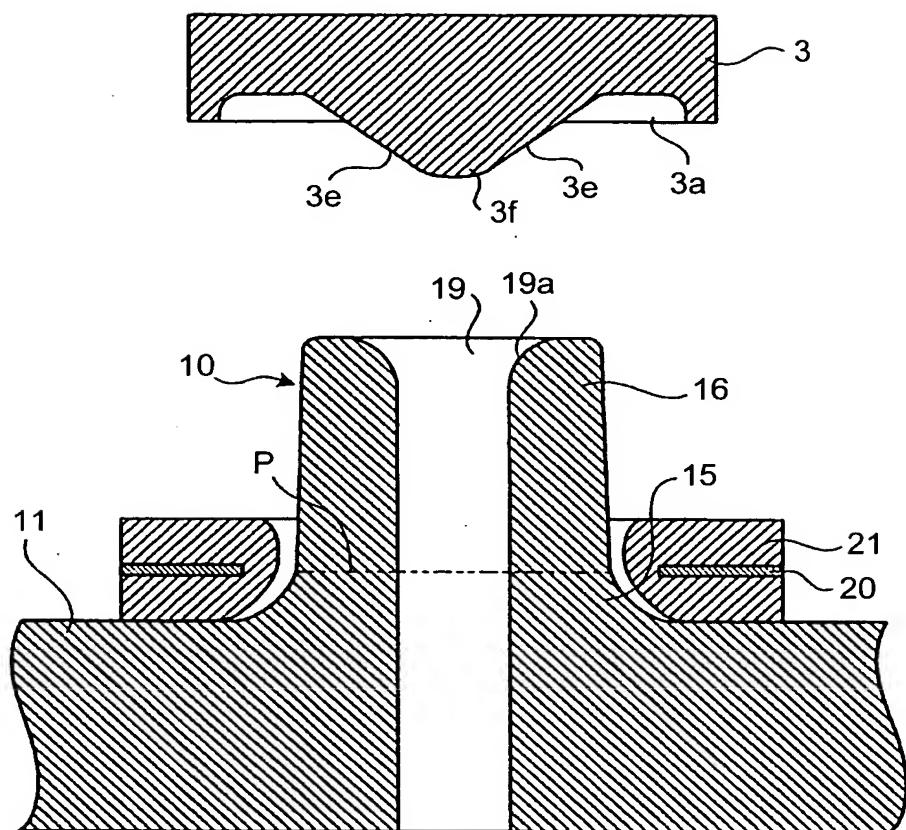


FIG.25

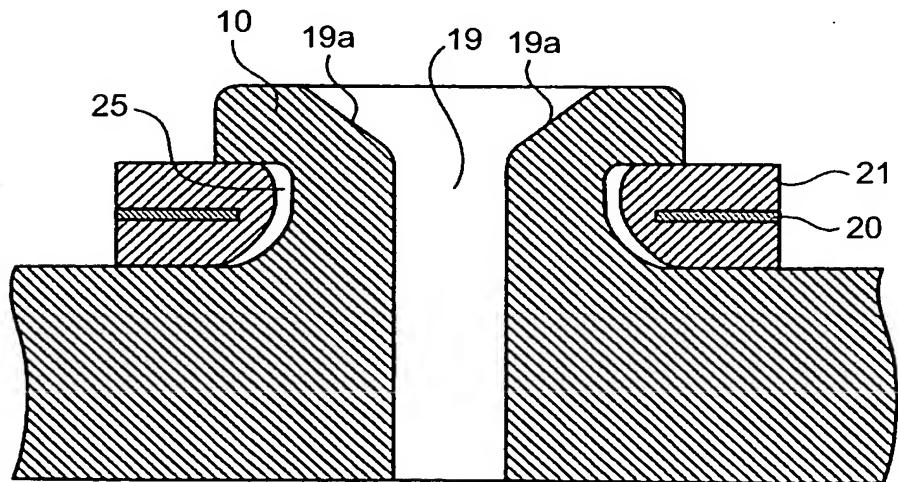


FIG.26

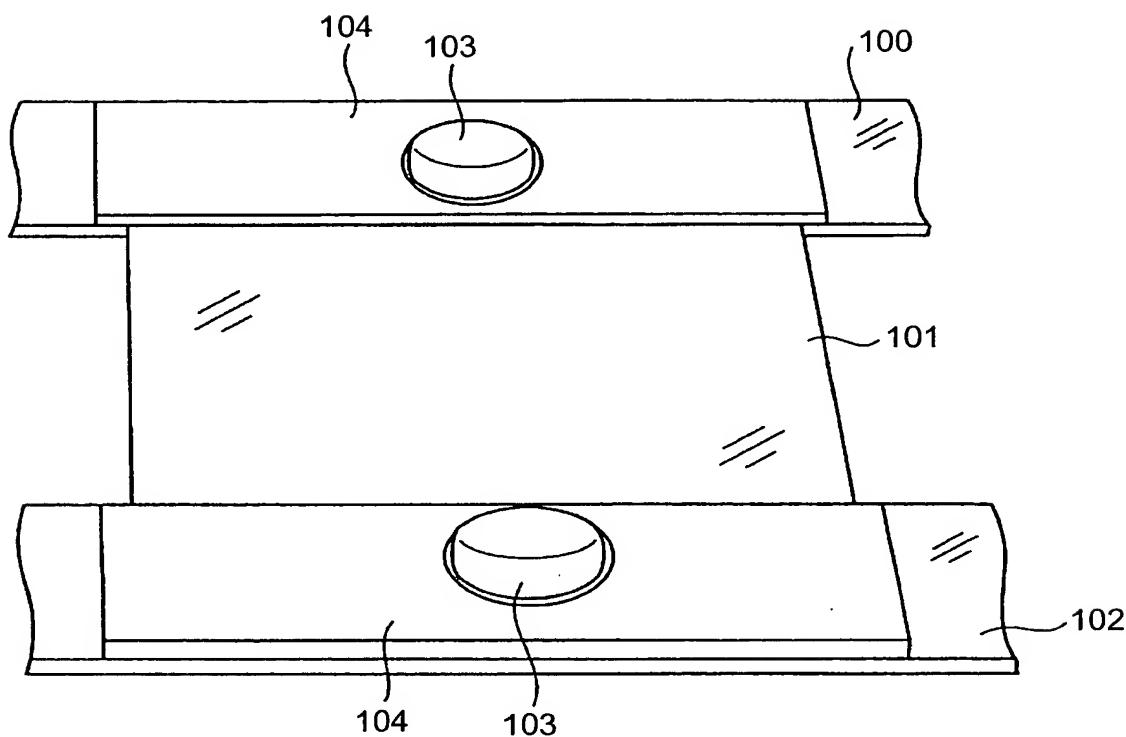


FIG.27

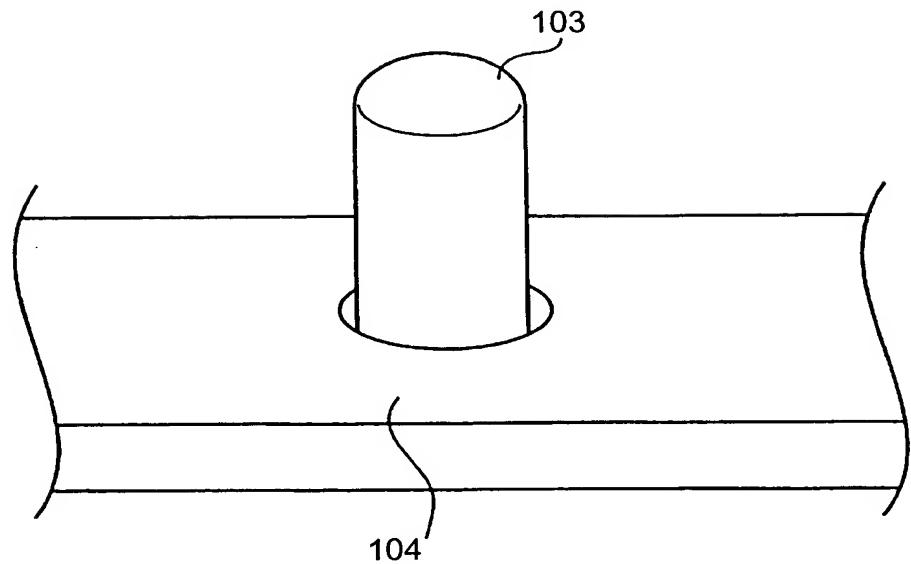


FIG.28

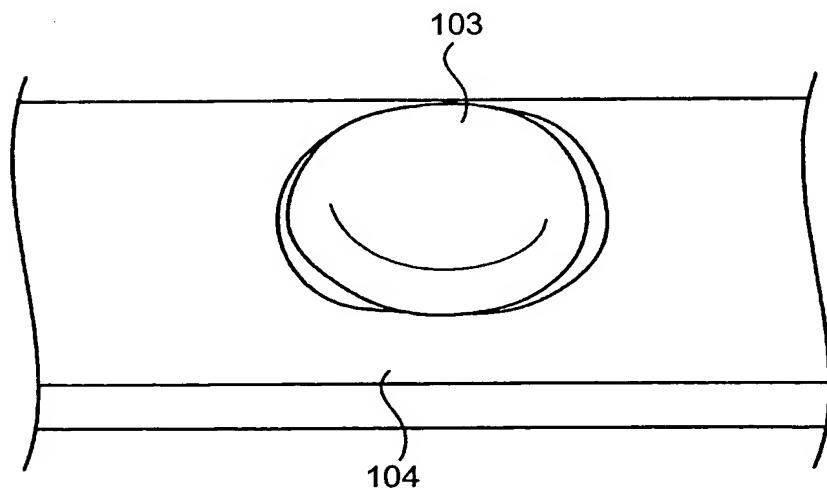


FIG.29

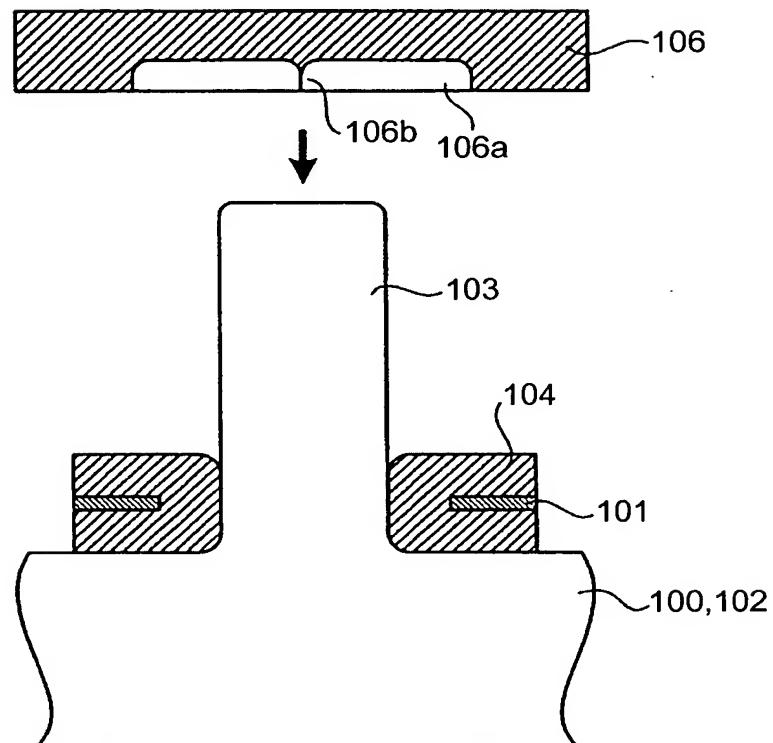


FIG.30

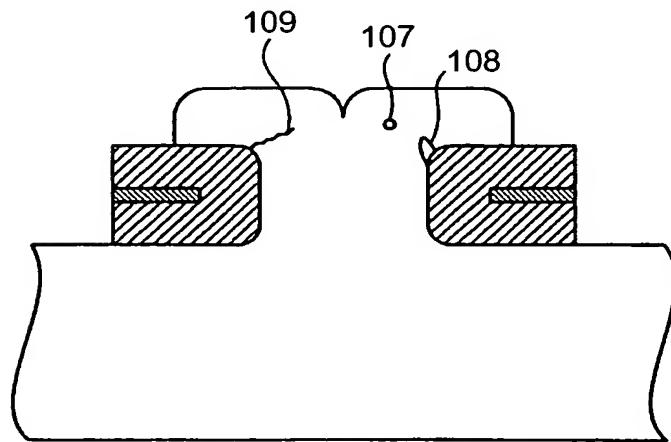


FIG.31

CAUSES PHENOMENA	EXCESSIVE ENERGY APPLIED	EXCESSIVE DEFORMATION OF MOLTEN RESIN	UNFAVORABLE DEFORMATION DIRECTION OF MOLTEN RESIN
VOID			
RIDGE			
CRACK			